

Work Order ID 162327

Friday, June 02, 2017 10:17:11 AM

162327

Page 1

Item ID: D5331-041 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Basket Base Assembly, LH
Start Date: 6/23/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 7/5/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference: SCHEDULED/C

Approvals: **Process Plan:**  **Date:** JUN 02 2017 **Tooling:** **Date:** **Run Start** ***NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5331	B

100

Weld per dwg A/R S.S. rod Batch 4136695 0.00
Large Fab

100

Large Fab

Large Fab

Memo

2.77

1- Assemble ribs and weld as per dwg D5331 using DT10197
inspect before welding mesh
54.63 CRITICAL DIMENSION

2- Weld gusset and handle plate as per dwg

3- Cut mesh as per dwg D5328-1

4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends

5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331
Take lid to locate hinge and bracket
On one of the hinge weld stopper D4016-7 as per dwg

6- Weld D5325-5 foot as per dwg (CRITICAL)

/x

DAS
43
9-89 JUL 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
JUL 10 2015								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							DAS 9 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							DAS 9 9-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.28							1 φ 17 07 12 34 9-89

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Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
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Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

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Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>wb</u>	0.00							
170									
Packaging	Memo	0.01							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

5337-041 / 13162322 1x 17/7/20 14/62/12



JUL 19 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, June 02, 2017 10:17:10 AM

Page 1

Work Order ID: 162327

162327

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP
REV:B 17.03.27 add D4016-7 DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4016-7		Manufactured	No			100	Each	7.0000	1	1		DAS 43 9-89	JUN 27 2017
✓ *D4016-7*													
Stop													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				7					
					158867			7					
D2581		Manufactured	No			100	Each	58.0000	2	2		DAS 43 9-89	JUN 27 2017
✓ *D2581*													
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				58					
					152803			2					
					159116			2					
					161800			54					
D3913-15		Manufactured	No			100	Each	41.0000	1	1		DAS 43 9-89	JUN 27 2017
✓ *D3913-15*													
Wide Handle Plate													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				41					
					157671			1					
					161938			40					

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, June 02, 2017 10:17:11 AM

Page 2

Work Order ID: 162327

162327

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100

Each

106.0000

6

6

✓ *D4016-1*

Hinge Half, Base

**B159537 → 6x DAS 43 JUN 27 2017 9-89

Location

Loc Qty

Loc Code

WA004

106

154145

2

158630

4

159537

100

D4021-1

Manufactured No

100

Each

66.0000

1

1

✓ *D4021-1*

Handle Plate

**B161473 → k DAS 43 JUN 27 2017 9-89

Location

Loc Qty

Loc Code

WA004

66

161473

36

161900

30

✓ M304EX0.75-16F

Purchased No

100

sf

513.5000

32

33.68421

M304FX0 75-16F

Expanded Metal Flat SS

**DC 2017-06-28

Location

Loc Qty

Loc Code

WA004

513.5

M136991

13.9

M137421

36.6

M137491

463

D5328-3

Manufactured No

100

Each

1.0000

1

1

✓ *D5328-3*

Mesh Base, Aft

**B163109 → 1x DAS 43 JUN 28 2017 9-89

Location

Loc Qty

Loc Code

WA006

1

159015

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5328-5

Manufactured No

100 Each

2.0000

1 1

DAS

✓ *D5328-5*

Mesh Base, Fwd

**B159377 → 1x DAS 43 JUN 28 2017
9-89

Location

Loc Qty

Loc Code

WA006

2

159377

2

D5330-1

Manufactured No

100 Each

10.0000

2 2

DAS

✓ *D5330-1*

Handle Plate

**B161957 → 2x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

10

161957

10

D3916-5

Manufactured No

100 Each

5.0000

2 2

DAS

✓ *D3916-5*

Light Rib

**B161959 → 2x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

5

161510

5

D5325-041

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5325-041*

Rib Assembly

**B159823 → 1x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159823

1

D5325-5

Manufactured No

100 Each

4.0000

4 4

DAS

✓ *D5325-5*

Foot

**B158879 → 4x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

4

158879

4

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Shop Packet Print

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DQA: _____ Date: _____



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Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5325-3 Manufactured No

100 Each

2.0000

1 1

DAS

✓ *D5325-3*

Light Rib

**B 162098 → 1x

43

9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

2

162098

2

D5326-041 Manufactured No

100 Each

0.0000

1 1

DAS

✓ *D5326-041*

Rib Assembly

**B 162339 → 1x

43

9-89

JUN 27 2017

D5326-043 Manufactured No

100 Each

0.0000

1 1

DAS

✓ *D5326-043*

Rib Assembly

**B 162340 → 1x

43

9-89

JUN 27 2017

D5327-1 Manufactured No

100 Each

9.0000

1 1

DAS

✓ *D5327-1*

Rib

**B 158897 → 1x

43

9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

9

158897

9

D5327-3 Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5327-3*

Rib

**B 159828 → 1x

43

9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

1

159828

1

D5327-5 Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5327-5*

Rib

**B 159829 → 1x

43

9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

1

159829

1

Friday, June 02, 2017 10:17:11 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 5

Work Order ID: 162327

162327

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5327-7

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5327-7*

Rib

** B159830 → 1x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159830

1

D5327-9

Manufactured No

100 Each

2.0000

2 2

DAS

✓ *D5327-9*

Rib

** B163112 → 2x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

2

159831

2

D5327-11

Manufactured No

100 Each

0.0000

4 4

DAS

✓ *D5327-11*

Rib

** B162341 → 4x 43 JUN 27 2017
9-89

D5327-13

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5327-13*

Rib

** B159832 → 1x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159832

1

D5327-15

Manufactured No

100 Each

18.0000

1 1

DAS

✓ *D5327-15*

Cap

** B161209 → 1x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

18

161209

18

Friday, June 02, 2017 10:17:11 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, June 02, 2017 10:17:11 AM

Page 6

Work Order ID: 162327

162327

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 6/23/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5329-1

Manufactured

No

100

Each

12.0000

2

2

✓ *D5329-1*

Gusset

**B162099 → 2x

DAS
43
9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

12

162099

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

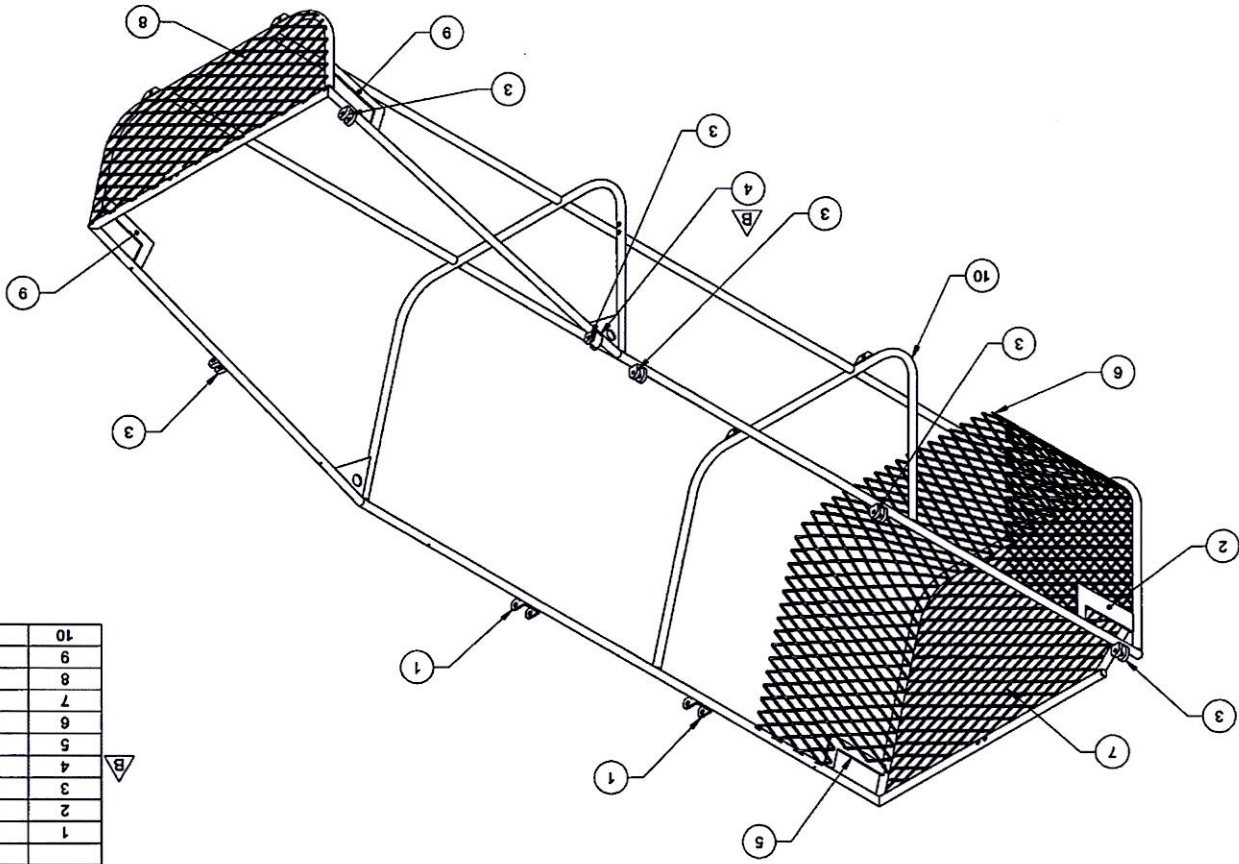
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART OSI 005 4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 29.8 lbs
 - 8) INSTALL AFTER FINISH
 - 9) MASK HOLES PRIOR TO POWDER COAT
 - 10) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5331-041
 - 11) WELD PER DART OSI 004
 - 12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

D5331-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)



APPROVED

DATE 17.02.09
DE APPR. D5331
APPROVED HS
MFG. APPR. DD
CHECKED VS
DRAWN RF
DESIGN RF

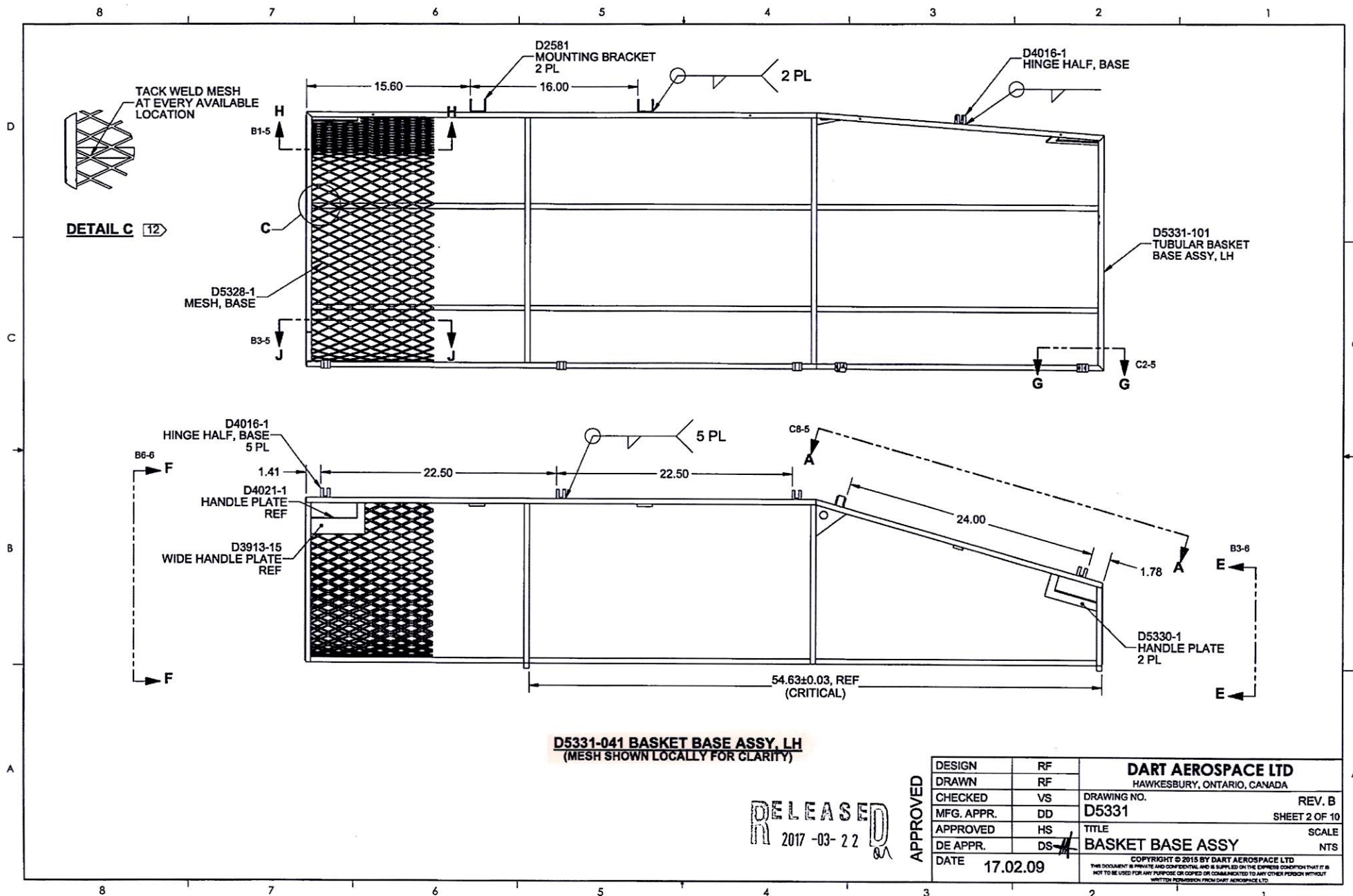
REV.	DESCRIPTION	DATE
A	NEW ISSUE	15.08.10
B	REVISE: 041/042 & BOM TO ADD D4016-7 STOP (2N A4-1, D3-1, A4-3, D3-3); ADDED DETAIL K (2N C6-5, D4-5)	17.02.09

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	D5331
DATE	17.02.09

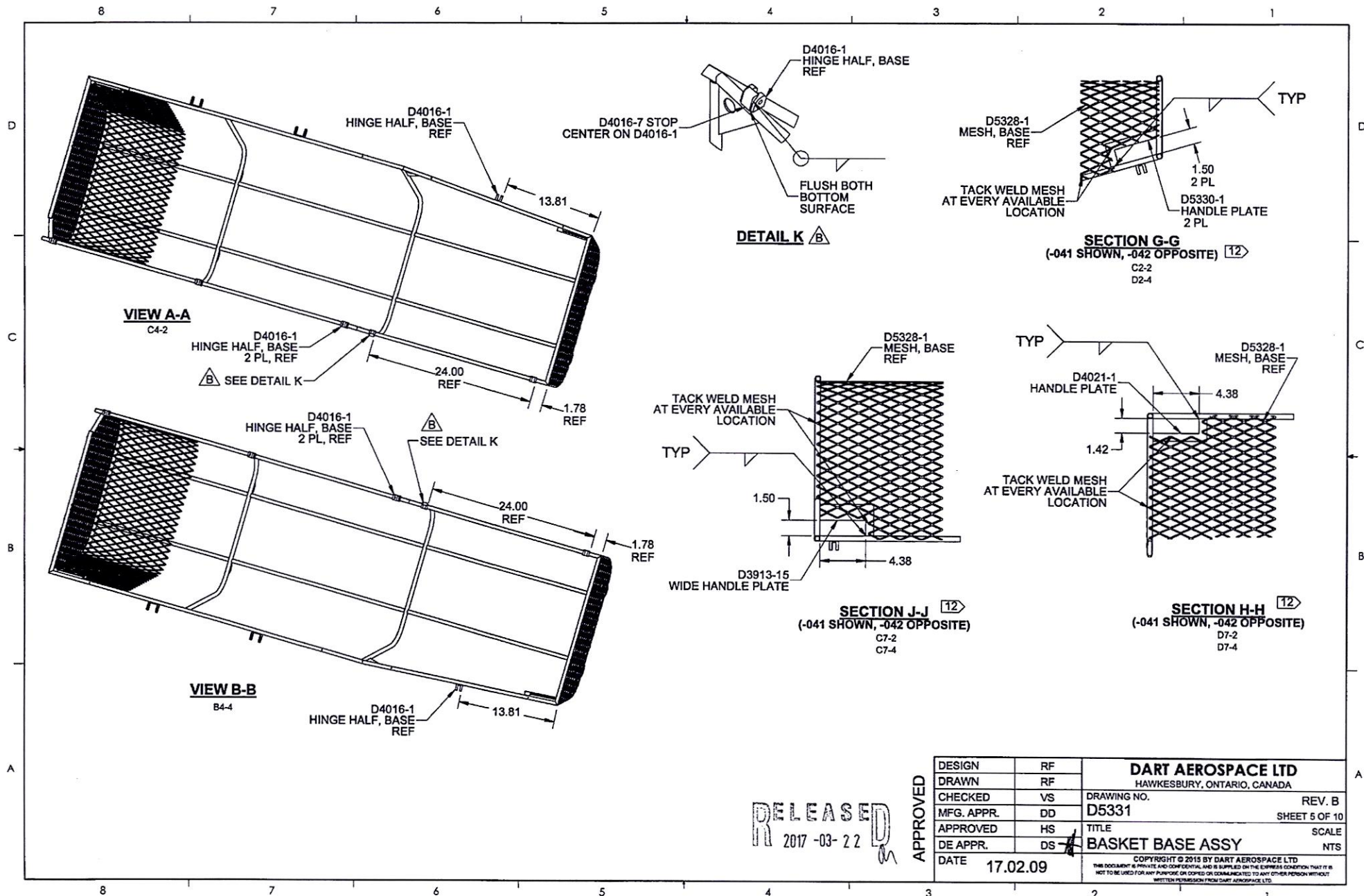
DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
REV. B	SHEET 1 OF 10
SCALE	NTS
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSE OR COMED ON COMPLAINT TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

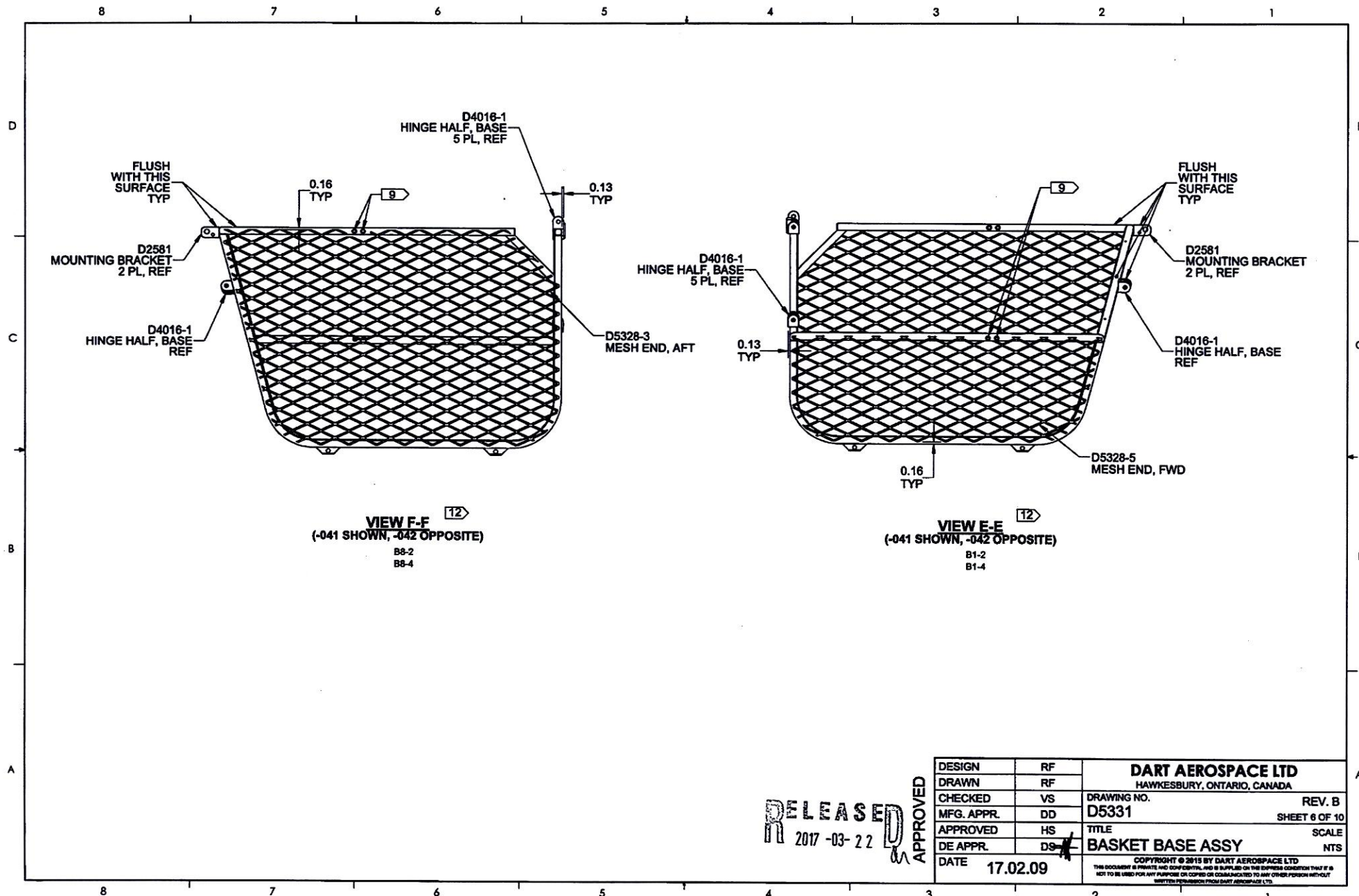
ITEM	QTY.	P/N	DESCRIPTION
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4016-7	STOP
5	1	D4021-1	HANDLE PLATE
6	1	D5328-1	MESH, BASE
7	1	D5328-3	MESH END, AFT
8	1	D5328-5	MESH END, FWD
9	2	D5330-1	HANDLE PLATE
10	1	D5331-101	TUBULAR BASKET BASE ASSY, LH

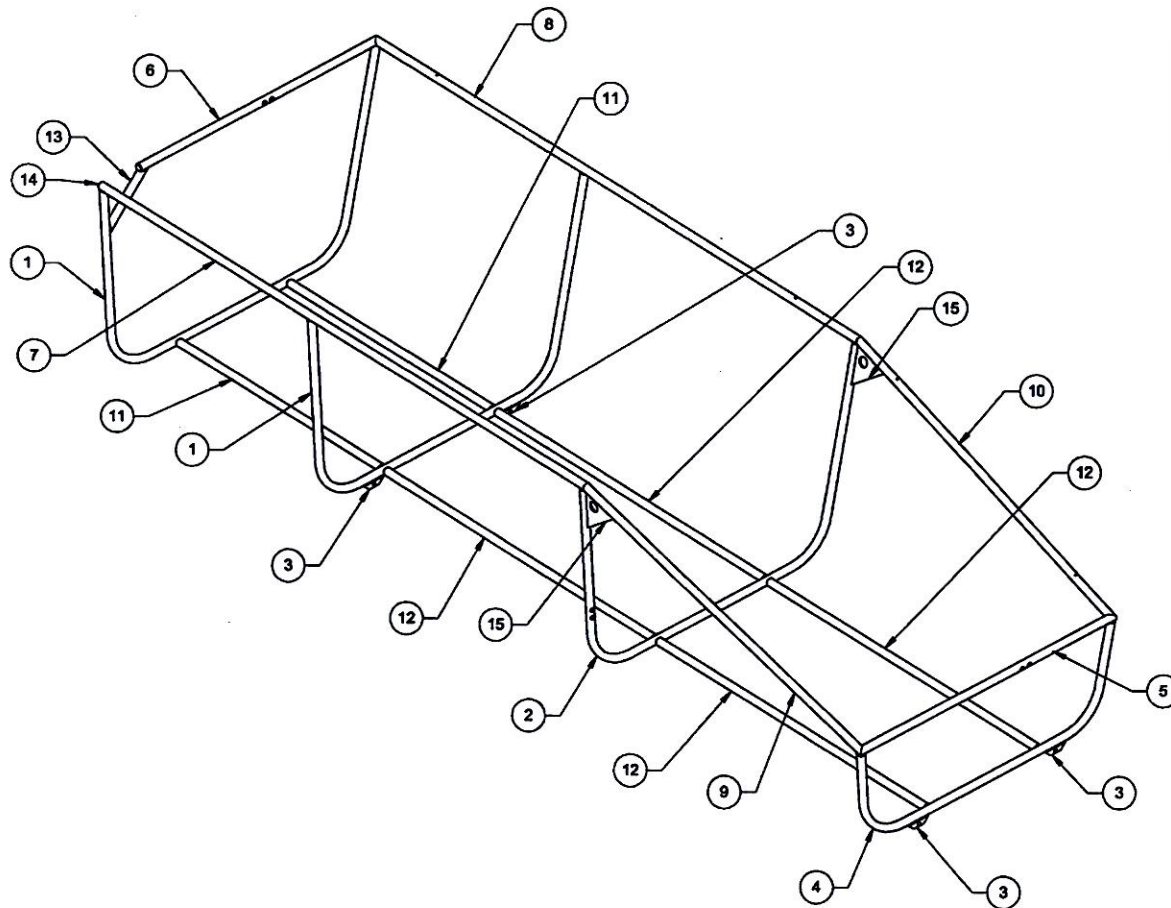
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162327
JUN 02 2017



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5331	SHEET 2 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	







D5331-101 TUBULAR BASKET BASE ASSY. LH

ITEM	QTY -101	P/N	DESCRIPTION
	X	D5331-101	TUBULAR BASKET BASE ASSY, LH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-5	FOOT
4	1	D5325-3	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-3	RIB
9	1	D5327-5	RIB
10	1	D5327-7	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

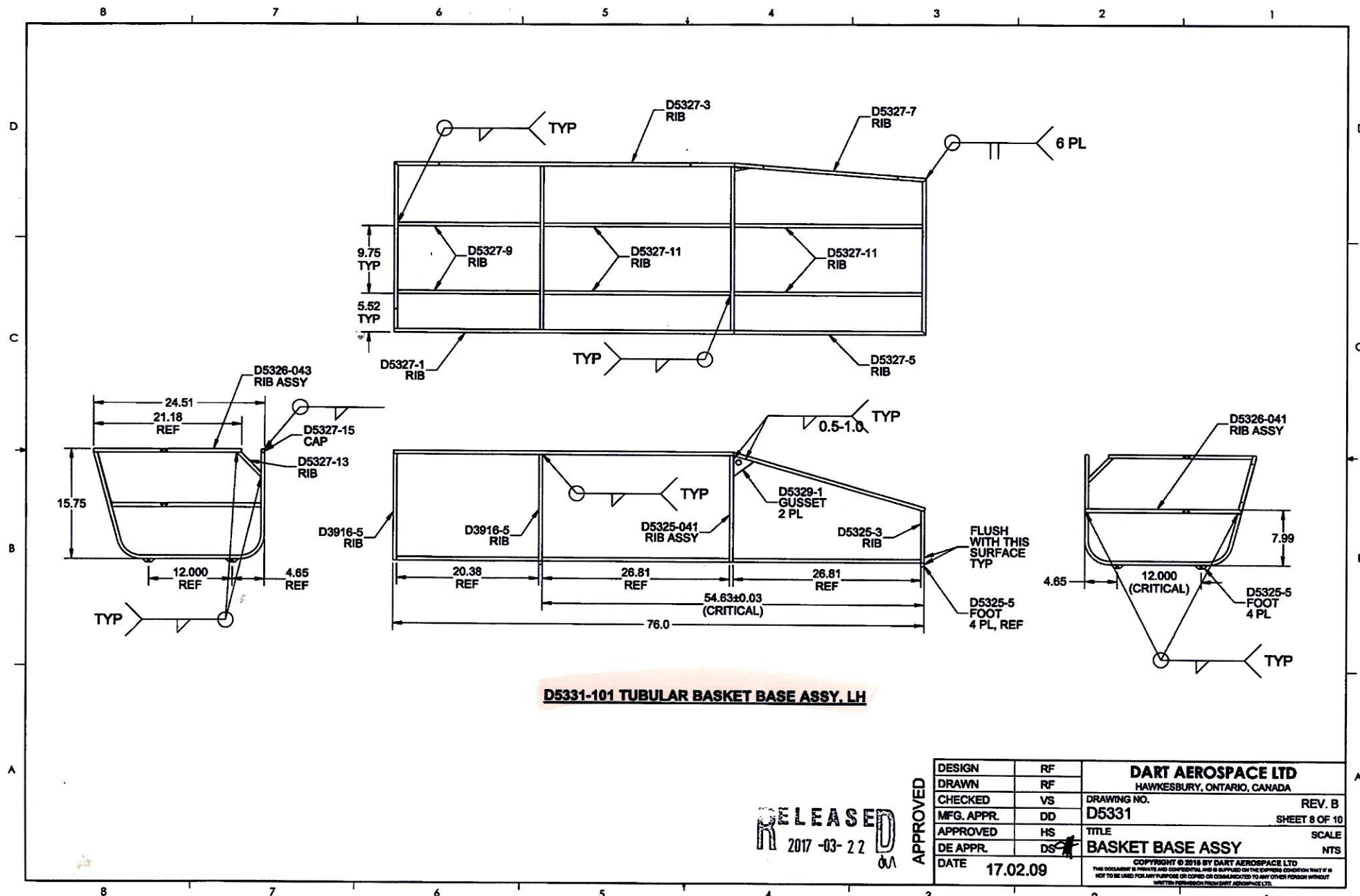
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 12.16 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5331-101
- 9) WELD PER DART QSI 004

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5331	SHEET 7 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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 2017-03-22

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